

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021472**Date Inspected:** 22-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China

CWI Name:	Mr. AN QIANG XING		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the side plate to side plate transverse splice weld joint located on 11DW+11EW at counter weight side. The weld is designated as OBW11C-006 & 007. The welder is identified as 040611. ZPMC QC Mr. WANG ZHU was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as WR-17444.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the bottom plate to bottom plate transverse splice weld joint located on 11DW+11EW. The weld is designated as OBW11C-008. The welder is identified as 046709. ZPMC QC Mr. WANG ZHU was onsite monitoring the welding variables.

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The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as WR-17471. See the attached picture for weld detail.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the bottom plate to side plate hold back weld joint located on 11CE+11DE at cross beam side. The weld is designated as SEG070A-011(11CE) & SEG072A-021(11DE). The welder is identified as 044515. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as CWR-2267.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the bottom plate to side plate hold back weld joint located on 11CE+11DE at bike path side. The weld is designated as SEG070A-012(11CE) & SEG072A-043(11DE). The welder is identified as 053871. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as CWR-2268.

ABF Quality Control (QC) personnel performing Ultrasonic Testing (UT) for the side plate to side plate transverse splice weld joint located on 11DE+11EE at bike path side. The weld is designated as OBE11C-009 & 010.

ABF Quality Control (QC) personnel performing Ultrasonic Testing (UT) for the bottom plate to bottom plate transverse splice weld joint located on 11DE+11EE. The weld is designated as OBE11C-008.

ABF Quality Control (QC) personnel performing Magnetic particle Testing (MT) for the side plate to side plate transverse splice weld joint located on 11CW+11DW at counter weight side. The weld is designated as OBW11B-007.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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